

Date: Wednesday, 7/5/2006 3:11:42 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 EXTRUSION BENDING
Job Number	: 27831		
Estimate Number	: 10311		
P.O. Number	: N/A	Part Number	: D2620
This Issue	: 7/5/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2620 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27205	Drawing Revision	: B
Written By	: See J. S. Comment Below		
Checked & Approved By	: 06.07.05 W		
Comment	: Est. D 02/07.26 Change Dwg to rev.B; Updated Location RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26001160	Extrusion Round 3" 206	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Extrusion Round 3" 206	
		Pick: Qty Part Number Description Batch	B24508 DP 6-7-7
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008	DP 6-7-7
		2- Cut Fwd end of tube as per Dwg D2620	06-07-7 (30)
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	BE 06-07-10 (30)
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: Z6	31- 06-07-10 (30)
5.0	DC	DOCUMENT CONTROL	
			(30)
		Comment: DOCUMENT CONTROL Inspection Level 21	DP 06-07-11
			11 06-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA: Date: 06/07/11

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: _____

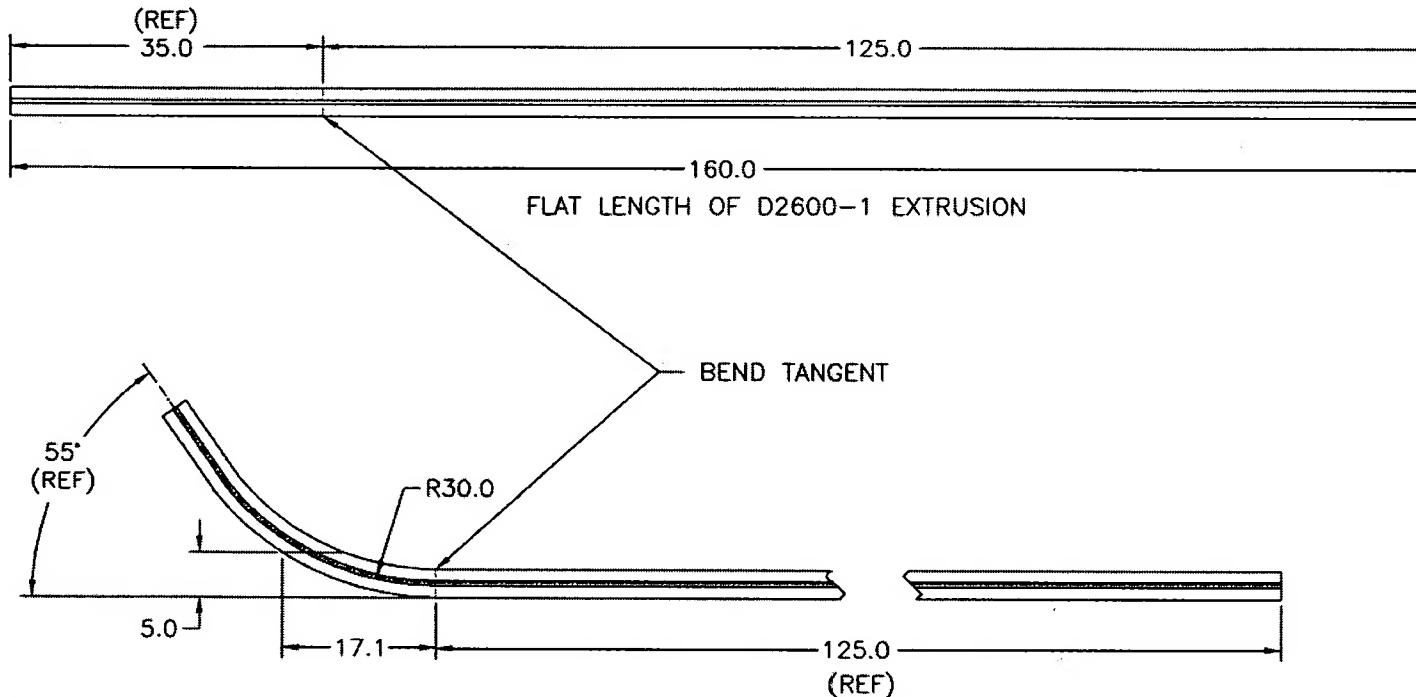
Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

SPECIFICATION CONTROL DRAWING
206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
44-04-15 DS

DART

COPY
DATE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
	RF	FARCHILD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	DRAWING NO.
	KL	D2620
DATE		TITLE
99.09.10		206 SKIDTUBE BENDING CONTROL
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING
		SCALE
		1:20
		REV. B
		SHEET 1 OF 1